

PRODUCT BULLETIN
GYPSUM PRODUCTS

GYPSUM BOARD
1/2" REGULAR

BULLETIN NO: B-3
DATE: 12/1/77
PAGE: 1 of 2

APPROVALS:

A.S.T.M. C-36

CANCELS: B-3
DATE: 9/12/75

PRODUCING PLANTS: Long Beach, Antioch, Seattle

CORE FORMULA (lbs/MSF):

| | | |
|---------------------|-----------|-------------|
| Board Stucco | (S-1) | 1250 - 1400 |
| Paper Fiber | (B-G-1) | 0 - 15 |
| Glass Fiber | (B-G-1) | 0 - 1.5 |
| Starch | (RM-B-11) | 7 - 12 |
| with sanders | | 5 - 8 |
| Dextrose | (RM-B-3) | 0 - 3 |
| Foaming Agent | (B-G-1) | 0.2 - 1.4 |
| Lignin - Dry Powder | (B-G-1) | 2.5 - 3.5 |
| - Liquid (Seattle) | (B-G-1) | 5.0 - 7.0 |
| End Trim | (B-G-1) | 10 - 40 |
| Potassium Sulfate | (B-G-1) | 0 - 2.0 |
| Retarder | (B-G-1) | 0 - 0.5 |
| Hydrated Lime | (RM-P-3) | 0 - 0.5 |
| Boric Acid | (B-G-1) | 0 - 1.0 |

Paper Liners (RM-B-1): Use Grade #7001 Manila and Grade #7002 Greyback for face and back paper respectively, except use Grade #7010 Partition Board - Manila and Grade #7013 Partition Board Greyback for face and back paper respectively on all 1/2" board manufactured for use in partitions.

OPERATING SPECIFICATIONS: Refer to Process Bulletin B-G-2 for General Operating Specifications.

- | | |
|------------------------------------|-----------|
| 1. Slurry Slump (inches) | 4½ - 8 |
| 2. Slurry Setting Time (minutes) | 2 - 4½ |
| 3. Wet Slurry Weight (lbs/cu. ft.) | 62 - 70 |
| 4. Wet Compressive Strength, psi) | 150 - 300 |

| | | |
|-------------------------------------|------------------------------|---|
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| APPROVALS: <i>[Signature]</i> | A.S.T.M. C 36 | CANCELS: B-3 DATE: 9/12/75 |

PRODUCING PLANTS: Long Beach, Antioch, Seattle

PRODUCT SPECIFICATIONS: (Refer to Product Bulletin B-G-4 for General Finished Product Specifications).

| | Acceptance Limits | | Control Values | | |
|----------------------|-------------------|------|----------------|------|------|
| | Min. | Max. | Min. | Std. | Max. |
| Wet Weight (lbs/MSF) | | | 2600 | | 2875 |

TAKE-OFF TESTS

| | | | | | |
|--|---|-------|-------|-------|-------|
| Dry Weight (lbs/MSF)* | 1650 | 1825 | 1700 | 1750 | 1850 |
| Evaporation Loss (lbs/MSF) | | | 700 | | 900 |
| Thickness, Average (inch) | 0.484 | 0.516 | 0.484 | 0.490 | 0.510 |
| Thickness, indiv. rdg. (inch) | ± 0.010 from avg. ± 0.010 from average. | | | | |
| Twist Test, tested hot face & back (inch) | | | | 0 | 2 |
| End Peel, tested @ 1-2 hours face and back (inch) | | | | 0 | 1 |
| Bond Test, tested @ 1-2 hours face and back (inch) | | 2 | | 0 | 1 |
| Falling Ball Impact (inch) | | | 0.020 | | 0.050 |
| Edge Hardness (lbs) | 8 | | 10 | 14 | 18 |

STANDARD CONDITIONED SAMPLE TESTS

| | | | | | |
|---------------------------|------|-----|------|------|-----|
| Flexural Strength, (lbs) | | | | | |
| Across | | | 140 | 150 | |
| Parallel | 40 | | 40 | 50 | |
| Deflection @ Break (inch) | | | | | |
| Across | 0.30 | | 0.30 | 0.35 | |
| Parallel | 0.20 | | 0.20 | 0.25 | |
| Punch Test (lbs) | 550 | 900 | 550 | 600 | 900 |
| End Peel after Sawing | | 1 | | 0 | 1/2 |
| Twist Test (inch) | | | | | |
| face and back | | 2 | | 0 | 1 |
| High Humidity Bond (inch) | | | | | |
| face and back | | 1 | | 0 | 1 |
| Nail Pull Resistance | 80 | | 80 | 90 | |

* NOTE: Board manufactured outside the specified dry weight ranges may be shipped provided board conforms to all other finished product specifications.